

TECHNICAL DATA SHEET

TECHNYL A 246 NC
(Previously DOMAMID 66I4 NC)

Polyamide 66, impact modified, for injection moulding

General

Feature	Impact modified
Polymer type	PA66 (Polyamide 66)
Processing technology	Injection molding
Certification	RoHS

Product identification

ISO 1043 abbreviation	PA66-I
ISO 16396 designation	PA66-I,M1,S14-020

Condition	Standard	Unit	Value
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Physical properties

Density		ISO 1183	g/cm ³	1.08
Molding shrinkage, parallel		ISO 294-4, 2577	%	1.4 - 1.6
Molding shrinkage, normal		ISO 294-4, 2577	%	1.6 - 1.8

Mechanical properties

dam / cond.*

Tensile modulus	1 mm/min	ISO 527-1/-2	MPa	1900 / 900
Strain at break	50 mm/min	ISO 527-1/-2	%	50 / 50
Yield stress	50 mm/min	ISO 527-1/-2	MPa	50 / 40
Flexural modulus, ISO 178	2 mm/min	ISO 178	MPa	1800 / -
Flexural strength, ISO 178	2 mm/min	ISO 178	MPa	70 / -
Charpy impact strength, +23°C	+23°C	ISO 179/1eU		NB / NB
Charpy impact strength, -30°C	-30°C	ISO 179/1eU		NB / NB
Charpy notched impact strength, +23°C	+23°C	ISO 179/1eA	kJ/m ²	65 / 105
Izod impact strength, +23°C	+23°C	ISO 180/1U		NB / NB
Izod notched impact strength, +23°C	+23°C	ISO 180/1A	kJ/m ²	65 / 95
Rockwell hardness		ISO 2039/2	ScaleR	110 / -

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	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10°C/min		ISO 11357-1	°C	262
Temp. of deflection under load, 0.45 MPa	0.45 MPa	ISO 75	°C	165
Temp. of deflection under load, 1.80 MPa	1.80 MPa	ISO 75	°C	65
Vicat softening temperature	50°C/h - 50N	ISO 306	°C	220

Electrical properties

Volume resistivity		IEC 62631-3-1	ohm.m	1E+016
Surface resistivity		IEC 62631-3-1	ohm	1E+014
Comparative tracking index	Solution A	IEC 60112	V	600
CTI performance level category		Sol A		PLC 0

Burning behaviour

Flammability, 0.75 mm	0.75 mm	UL 94		HB
Burning rate, FMVSS, Thickness 1 mm		FMVSS 302		< 100 mm/min

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for natural colored products.
*: conditioned according to ISO 1110

Processing conditions

Drying temperature/time	75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	270 - 290 °C
Recommended mould temperature	40 - 80 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part.

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